

Work Order ID 78739

78739

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January-13-12 9:55:23 AM

Item ID: D3138-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cover
 Start Date: 13/01/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 27/01/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: H.L.J Date: 12/01/13 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3138	Rev C								

100 0.00
 100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3138
 2024.037 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary
 2 0 Jm 12-8-18

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control 2 0 Jm 12-8-18

120 0.00
 120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control 12/08/11 12 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				2			SP 12/08/12
Small Fab	Memo	0.00							
Small Fab	Deburr								
	Bend as per Dwg D3138								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				2			
Quality Control	Memo	0.00							5MB 12-8-23 DAS 16 12/08/13
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				2			12-8-23
Hand Finishing	Memo	0.00							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
-----	------------------------------------------	------	--	--	--	--	--	--	--

160

Powdercoat
Powder Coating

Memo

START TIME: 9:00

OVEN TEMPERATURE: 3200F

FINISH TIME: 9:30

0.00

2X ✓

MZ 12/08/24

170	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

170

QC
Quality Control

Memo

0.00

2x ✓ 12/08/24

180	Identify as per dwg & Stock Location 241A	0.00							
-----	-------------------------------------------	------	--	--	--	--	--	--	--

180

Packaging
Packaging

Memo

0.00

2x ✓ 12/8/27

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Item ID: D3138-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cover

Start Date: 13/01/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 27/01/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

CK 12/8/28

MR
12-08-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-13-12 9:55:27 AM

Page 1

Work Order ID: 78739

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Parent Item: D3138-1

D3138-1

Parent Item Name: Cover

Start Date: 13/01/2012

Required Date: 27/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: B 04.11.29Made by Laser CutKJ/RF
 IPP Rev: C 05.12.13added level 5 EC
 IPP rev:D 08-05-12 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

110

sf

106.7000

1.8427

~~3.879368~~

M2024T3S 032

3.9

2024-T3 .032 sheet

Jun 12-8-18

Location

Loc Qty

Loc Code

MAT022

106.7

118243

30.7

118523

76

121309

121309

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78739
Description: Cover		Part Number:	D3138-1
Inspection Dwg: D3138 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.603	+/-0.010	0.598"	✓		✓	mmol
0.203	+/-0.010	0.199"	✓		✓	
1.82	+/-0.030	1.832"	✓		✓	
2.27	+/-0.030	2.293"	✓		✓	
2.49	+/-0.030	2.498"	✓		✓	
3.44	+/-0.030	3.436"	✓		✓	
1.42	+/-0.030	1.431"	✓		✓	
6.23	+/-0.030	6.230"	✓		✓	
12.46	+/-0.030	12.46"	✓		T	
18.47	+/-0.030	18.47"	✓		T	
24.52	+/-0.030	24.52"	✓		T	
30.76	+/-0.030	30.76"	✓		T	
37.00	+/-0.030	37.00"	✓		T	
43.13	+/-0.030	43.13"	✓		T	
49.20	+/-0.030	49.20"	✓		T	
55.26	+/-0.030	55.26"	✓		T	
61.10	+/-0.030	61.10"	✓		T	
67.23	+/-0.030	67.23"	✓		T	
72.33	+/-0.030	72.33"	✓		T	
77.14	+/-0.030	77.14"	✓		T	

Measured by:	Jm	Audited by:	DAS	Prototype Approval:	N/A
Date:	12-8-18	Date:	16 12/08/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.23	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

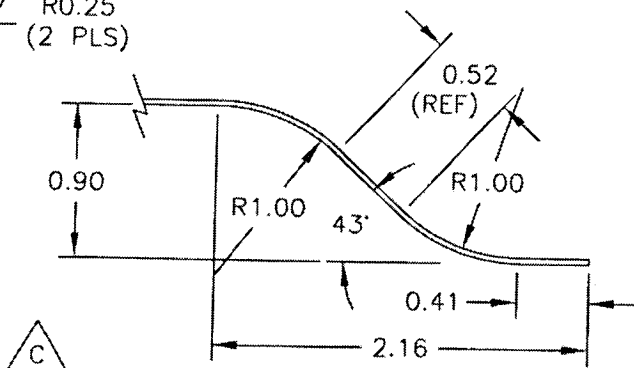
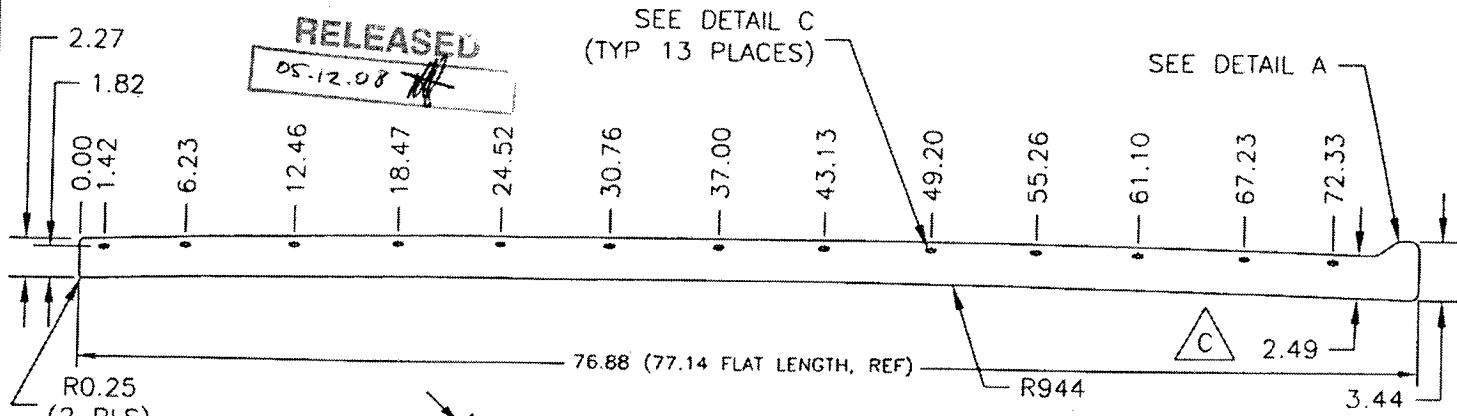
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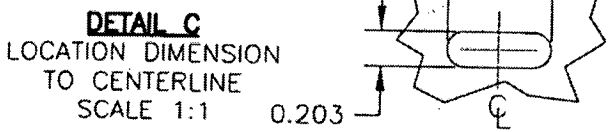
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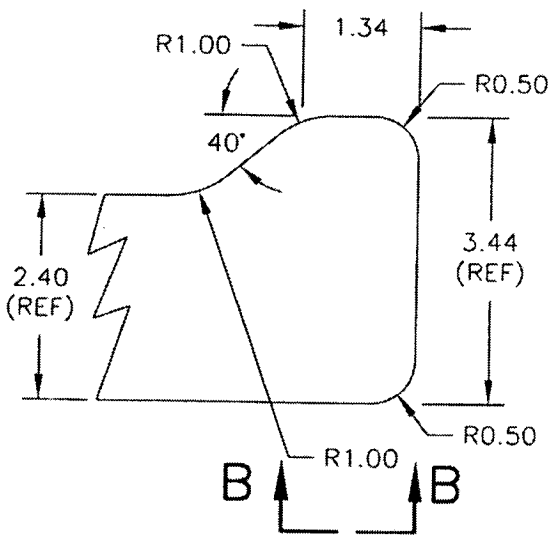
DART



VIEW B-B
BEND D3138-1 AS SHOWN
BEND D3138-2 OPPOSITE
SCALE 1:1



DETAIL C
LOCATION DIMENSION
TO CENTERLINE
SCALE 1:1



DETAIL A
FLAT PATTERN SHOWN
SCALE 1:2

DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3138
DATE	05.12.05	TITLE	COVER	REV. C SHEET 1 OF 1 SCALE 1:10
A	02.04.18	NEW ISSUE		
B	04.09.20	RE-DESIGN		
C	05.12.05	CORRECT VIEW B-B; ADD 2.49 DIM.		

D3138-1 COVER (SHOWN. REPLACES PREMIER P/N B30-23000-205)

D3138-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-206)

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC. M2024T3S:032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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SUBJECT TO CHANGE
WITHOUT NOTICE
WARRANTY
WARRANTY

NO. 70739 H.C.J.
12/01/13

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